

Work Order ID 165778

165778

Page 1

Monday, August 28, 2017 2:22:47 PM

Item ID: D5283-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Basket Clamp
 Start Date: 8/30/2017 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 9/15/2017 Req'd Qty: 10.00 *10* Customer:

Reference: DAS
 Approvals: Process Plan: 13 9-09 Date: AUG 28 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5283	A								
100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT TO 5.250" LG								
105		0.00							
105									
Purchasing	Memo	0.00							
Purchasing	Issue p.o.: 37611								
	Possible supplier: Metec								
	Machine, Alodine and powder Coat as per Dwg								
	C of C is required								

17/08/29

AUG 30 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Page 2

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 Item Name: Basket Clamp
 Start Date: 8/30/2017 Start Qty: 10.00 ***10*** Cust Item ID:
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging									

10x SPT 9-15

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

10 ϕ SEP 18 2017 DAS 9-89

210	Identify as per dwg & Stock Location: <u>Sts23</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging									

10 ϕ SEP 20 2017 DAS 9-89

SEP 18 2017 121 → Chemical conversion → 10 ϕ 179-19 DAS 34 9-89

122 → QC 7

123 → Powder coat white as per dwg in 138014

124 → QC 3

START: 1:50
 W.T: 320°
 Finish: 2:00

10 ϕ 1709-19 DAS 34 9-89

10 ϕ SEP 20 2017 DAS 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____		

Work Order ID 165778***165778***

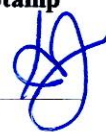
Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

17/9/21 

17/9/20 

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, August 28, 2017 2:22:46 PM

Page 1

Work Order ID: 165778

165778

Parent Item: D5283-11

D5283-11

Parent Item Name: Basket Clamp

Start Date: 8/30/2017

Required Date: 9/15/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 15-07-06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5283-11P		Purchased	No			105	Each	0.0000	1	10			
D5283-11P									**				
Basket Clamp													
M6061T6B1.000X02.00		Purchased	No			100	f	39.0000	0.46	4.842105			
0													
M6061T6B1 000X02 000									**				
6061-T6 Bar 1.00 x 2.00													

Location

MAT

- M137980

M138152

Loc Qty

39

19

20

Loc Code

4.85

FM 17/08/29

57.75

DQA: _____ Date: _____

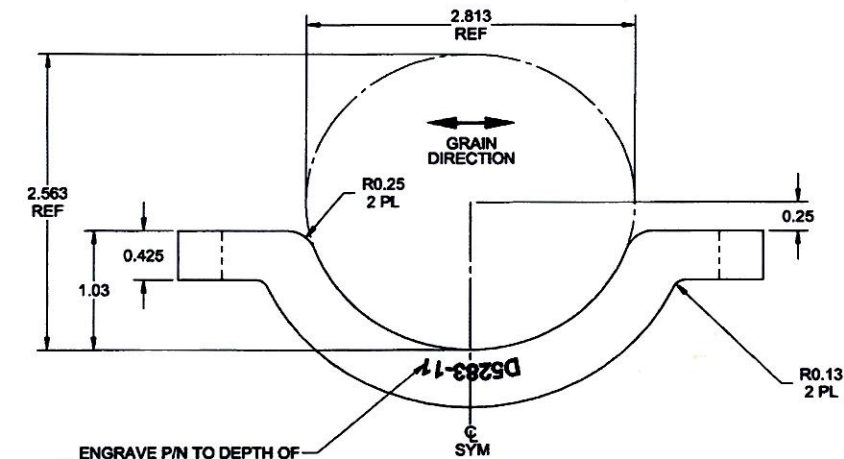
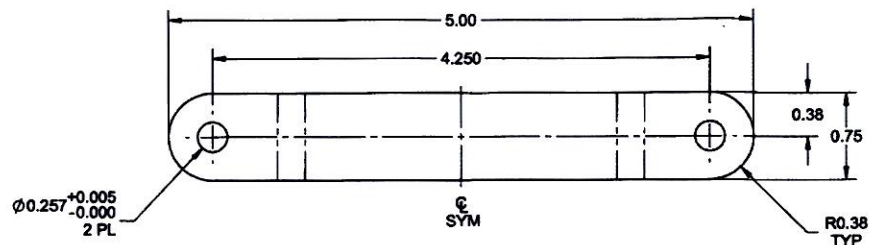


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OTHER : ☐					



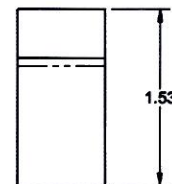
ENGRAVE P/N TO DEPTH OF
0.010 $\pm$ 0.005 IN THIS LOCATION
WITH TOOL TIP RAD OF 0.015 $\pm$ 0.005

D5283-11 BASKET CLAMP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS D5283-11 PER QSI 044 6.3
- 7) WEIGHT: 0.20 lbs
- 8) NON DIMENSIONED FEATURES-REFER TO 3D CAD FILE D5283-11.Rev A.STEP

AUG 28 2017
DAS
13
9-59



RELEASED
2015-07-20

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 6 OF 6
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
	DATE	15.06.30	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37611

Purchase Order Date 8/30/2017

PO Print Date 9/1/2017

Page Number 2 of 3

Order From :
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

3	D5283-11P	Basket Clamp	9/12/2017	FN	10.00	\$12.75	\$127.50
			Yes		Each		
			9/12/2017				

Machine as per Dwg D5283
Rev. A B165778

NO ALODINE AND POWDER COAT

DAS
9
9-89

SP17-9-15

Line Total: \$127.50

4	D5283-7P	Basket Clamp	9/12/2017	FN	10.00	\$12.75	\$127.50
			Yes		Each		
			9/12/2017				

Machine as per Dwg D5283
Rev. A B165779

NO ALODINE AND POWDER COAT

Line Total: \$127.50

Note:

9/1/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21854
Date: Sep 14, 2017
Page: 1

Sold to:**Dart Aerospace Ltd.**

Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

Ship to:

Dart Aerospace Ltd.
Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

Order No.: 37611**Sold By:** Walz, Christian D.**Shipped By:** your truck**Ship Date:** Sep 14, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5283-1 Basket Clamp, no finishing no set up fee, will be done at the same time as PO 37426	Each	10	10	
D5283-3 Basket Clamp, no finishing Set-up fee for quantities below 25 pcs.	Each	10	10	
	Each	1	1	
✓ D5283-11 Basket Clamp, no finishing no set up fee, will be done at the same time as PO 37426	Each	✓ 10	✓ 10	
D5283-7 Basket Clamp, no finishing no set up fee, will be done at the same time as PO 37426	Each	10	10	

SPA-9-15.

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>		<u>P.O. NUMBER</u>
10	D5283-1P	Basket Clamp	Material B165774	37611
10	D5283-3P	Basket Clamp	Material B165775	37611
10	D5283-11P	Basket Clamp	Material B165778	37611
10	D5283-7P	Basket Clamp	Material B165779	37611

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, September 14, 2017